

Work Order ID 92119 -1

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Item ID: PB67-43001-13

Revision ID:

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

Required Date: 11/2/2012 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 12-10-25 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-13

Rev C

100

100

Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding
2- assemble parts and weld as per dwg
3- grind weld flush in area of PB67-43001-249 only
4- install helicol insert as per dwg

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(4/x)

CC 12-12-4

x4

0

05
12-12-04

18

15
9-89

12 12 05

4

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Item ID: PB67-43001-13 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: A Adjustable Blade Support Assembly
 Start Date: 10/23/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/2/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150	HandFinish					4	75	12-12-5	
Hand Finishing	Memo	0.00							

160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160	Powdercoat								
Powder Coating	Memo	0.00							

1- MASK TUBE FROM BASE TO GUSSET

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2-45
3200F
3-15

170	QC3- Inspect Part Finish	0.00							
170	QC								
Quality Control	Memo	0.00							

4X ✓ 12/12/10 MF
 4 φ 12/12/10 (259)

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Item ID: PB67-43001-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Adjustable Blade Support Assembly
 Start Date: 10/23/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/2/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Small Fab	Small Fab	0.00				<u>2</u>	<u>0</u>		<u>12.12.19</u>
	Memo	0.00							
Small Fab	1- match drill cover to existing holes in support 2- assemble as per dwg								
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				<u>2</u>	<u>0</u>		<u>12.12.19</u>
	Memo	0.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>W14</u>	0.00				<u>2</u>	<u>0</u>		<u>12.12.19</u>
	Memo	0.00							

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Item ID: PB67-43001-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Adjustable Blade Support Assembly

Stop

NS2

Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS 12-12-19

M 12-12-19

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Work Order ID: 92119

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

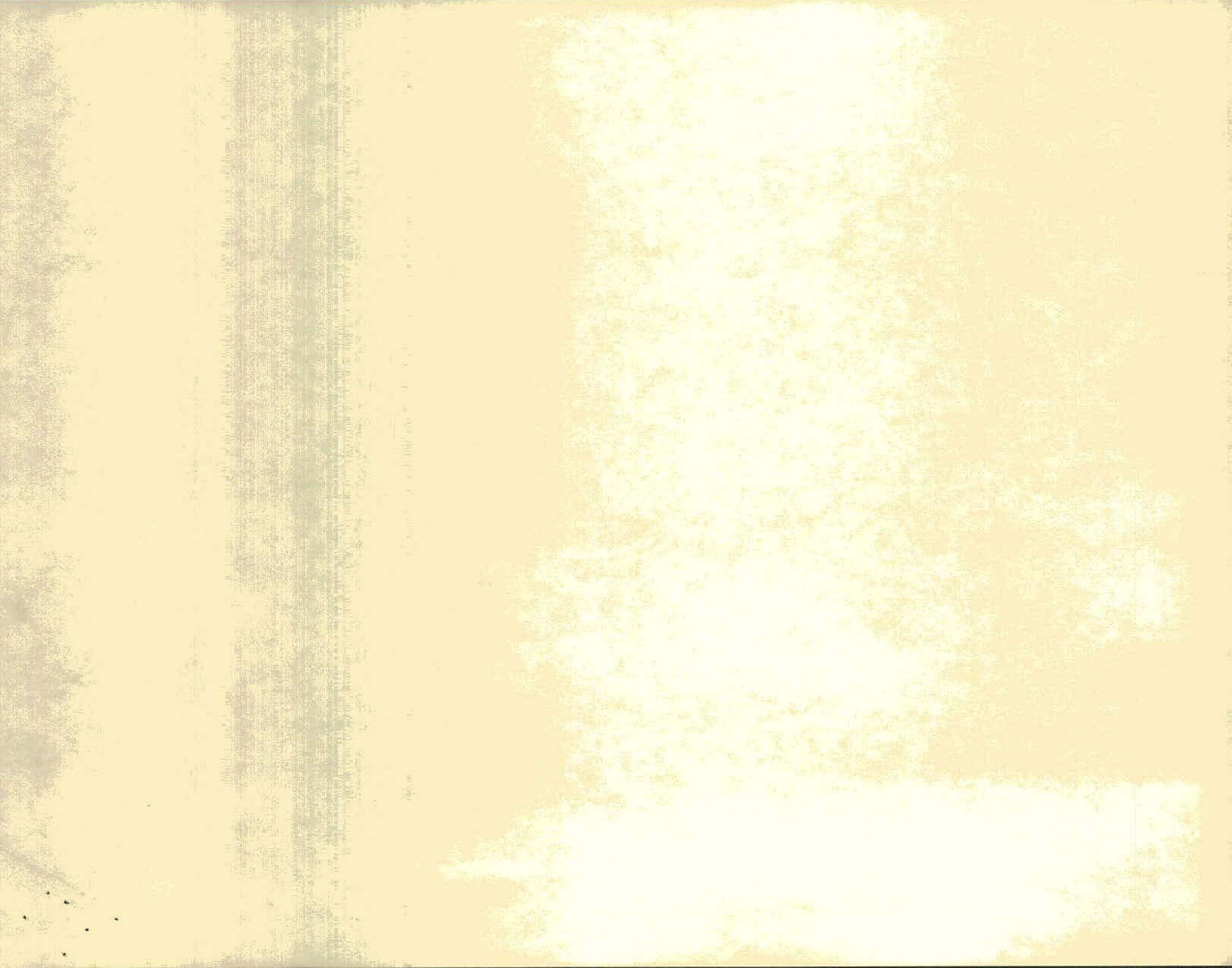
Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
EC verified by:DD IPP RevC 10.09.27 per RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
[REDACTED]		Manufactured	No				Each	1.0000		4		12.12.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				85187		1							
[REDACTED]		Manufactured	No			100	Each	3.0000	1	4		12.12.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		3							
				52480		3							
PB67-43001-253 Gusset		Manufactured	No			100	Each	7.0000	1	4		12.12.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7							
				85185		7							
PB67-43001-254 Gusset		Manufactured	No			100	Each	16.0000	1	4		12.12.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		16							
				52481		16							
[REDACTED] Inner Tube		Manufactured	No			100	Each	0.0000	1	4		12.12.04	
[REDACTED] HELICAL INSERT		Purchased	No			180	Each	82.0000	1	4		12.12.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		82							
				111064		82							



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Work Order ID: 92119**Parent Item:** PB67-43001-13**Parent Item Name:** Aft Adjustable Blade Support Assembly**Start Date:** 10/23/2012**Required Date:** 11/2/2012**Start Qty:** 4.00**Required Qty:** 4.00**MS27039-1-10**

Purchased

No

180

Each

416.0000

8

32

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
308 <u>B123522</u>	8	
122441	8	
GA	100	
120449	100	
ST291	5	
120120	5	
ST305	300	
122815	300	
ST308	3	
122027	3	

16**NAS1149D0316J**

Purchased

No

180

Each

400.0000

8

32

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	400	
122151	400	

16**NAS1149D0363J**

Purchased

No

180

Each

4,785.0000

8

32

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST294	1854	
123248	1254	
123355	600	
ST297	2820	
122378	2820	
ST298	111	
117601	61	
119537	33	
120308	17	

16

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Work Order ID: 92119

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

PB67-43001-69
90 Degree Cover Plate

Manufactured No

180

Each

1.0000

1

4

11.2.12.19

Location

ST437A

92087 =

1

Loc Qty

1

Loc Code

1

52433

1

PB67-43001-83

Manufactured No

180

Each

5.0000

1

4

11.2.12.19

PB67-43001-83

Location

ST444

890819 =

1

Loc Qty

5

Loc Code

1

53243

5

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B67-43001-11W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW 8
NAS1149JD0316J WASHER

B67-43001-69 90-DEGREE
COVER PLATE
REF

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-69
90° COVER PLATE ASSEMBLY

B67-43001-13W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT

MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL 8

B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

B67-43001-83
D-PAD ASSEMBLY, SHORT

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.21 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-13W AND B67-43001-83 TO B67-43001-69

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-13	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

